

Date: Wednesday, 6/6/2007 1:52:49 PM
 User: Kim Johnston

Process Sheet

26

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HELI UTILITY BASKET
Job Number	: 32787		
Estimate Number	: 10854		
P.O. Number	:	Part Number	: D350721041
This Issue	: 6/6/2007 S.O. No. :	Drawing Number	: N/A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: N/A
Previous Run	: 32535	Material	:
Written By	:	Due Date	: 6/30/2007 Qty: 1 Um: Each
Checked & Approved By	: <u>07.06.07</u>		
Comment	: Est Rev. B as per Rev B 05-11-21 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D350-721-041CHG002

07.06.11

2.0	32787A	BASKET LID ASSEMBLY
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Comment: Sub-Component BASKET LID ASSEMBLY

D3325-041 B 32787A

3.0	32787B	BASKET BASE ASSEMBLY
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Comment: Sub-Component BASKET BASE ASSEMBLY

D3324-041 B 32787B

4.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick: Assembly Kit

5.0	D2022101	Spacer
-----	----------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2022-101

Spacer 30543

1/1/31 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET

Job Number: 32787

Part Number: D350721041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2332041

Lid Prop Assembly 6.69"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description

Batch

1 D2332-041

prop arm

B 32572

MF 07-08-01

7.0

D2530

Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Handle Weldment

Batch:

31787

SQ

8.0

D2535

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description

Batch

2 D2535

Spring

B 31486

SQ

9.0

D2537

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description

Batch

2 D2537

Bushing

31107

SQ

10.0

D2931

Bumper



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description

Batch

2 D2931

Bumper

B 321139

SQ

11.0

D3320041

Webbing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description

Batch

1 D3320-041

Webbing

B 32586

7/2/31 SQ

W/O:		WORK ORDER CHANGES					
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Drawing Name: HELI UTILITY BASKET

Job Number: 32787

Part Number: D350721041

* Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D33511

Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 D3351-1

Label

1531664

13.0

AN316A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN3-16A

Bolt

1104093

SP

14.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN4-7A

Bolt

1102140

SP

15.0

AN420A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 AN4-20A

Bolt

116895

SP

16.0

AN422A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 AN4-22A

Bolt

1102959

SP

17.0

AN517A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 AN5-17A

Bolt

1104016

7/7/31 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Drawing Name: HELI UTILITY BASKET

Job Number: 32787

Part Number: D350721041

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

AN960JD416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN960JD416

Washer

M104215

SP

19.0

AN960JD416L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN960JD416L

Washer

M104214

SP

20.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 AN960JD516

Washer

M104156

SP

21.0

AN960JD8

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN960JD8

Washer

M104156

SP

22.0

AN960JD9

Washer



Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

32 AN960JD9

Washer

M16499

SP

23.0

AN9704

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 AN970-4

Washer

M103344

7/2/3159

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Drawing Name: HELI UTILITY BASKET

Job Number: 32787

Part Number: D350721041

* Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

32 MS20600AD4W3 Rivet

M104715

SP

25.0

MS20600AD4W2

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 MS20600AD4W2 Rivet

4747

SP

26.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 MS21042L3

Nut (or -3) M104547

SP

27.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 MS21042L4

Nut (or -4) M102552

SP

28.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 MS21042L5

Nut (or -5) M104118

7/8/31 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET

Job Number: 32787

Part Number: D350721041

Job Number:



Seq. #:

Machine Or Operation:

Description:

29.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg IIN-D350-721 Attach Travelers:

Seal rivet Holes with Sika Flex before riveting

A/R 291 Sika Flex Batch: M104732

Exp Date: 10/2007

MF 07-08-01

30.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Er 07/08/01 (+)

31.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

32.0

D22301

Mounting Lug



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

3 D2230-1

Lug

30992 ✓

SP

33.0

D22303

Mounting Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

4 D2230-3

Clamp

30993 ✓

SP

34.0

D2856400

Abrasion Strip



Comment: Qty.: 2.5200 f(s)/Unit Total: 2.5200 f(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

4 D2856-4007.20"

Abrasion Strip

1532992 ✓

7/2/31 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET

Job Number: 32787

Part Number: D350721041

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

D33381

Mounting Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D3338-1

Lug

~~1533697~~ 23797 ✓ SP

36.0

D3350041

Strut Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

2 D3350-041

Strut

1532867 ✓ 39

37.0

AN412A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

2 AN4-12A

Bolt

1104577 ✓ SP

38.0

AN413A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

8 AN4-13A

Bolt

1104746 ✓ SP

39.0

AN414A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 AN4-14A

Bolt

1102473 ✓ 7/2/07 SP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Date: Wednesday, 6/6/2007 1:52:49 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET

Job Number: 32787

Part Number: D350721041

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

AN960JD416

Washer



Comment: Qty.: 28.0000 Each(s)/Unit Total : 28.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

28 AN960JD416

Washer

M104215 ✓ SP

41.0

MS21042L4

Nut



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

18 MS21042L4

Nut (or -4)

M102552 ✓

7/7/31 SP (1)

42.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

43.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350721-041

Location:

PPP Rev:

7/8/02 (1)

44.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



7-07-08-02

07.08.02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

26

Date: Wednesday, 6/6/2007 1:53:03 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET LID ASSEMBLY
Job Number	: 32787A		
Estimate Number	: 10853		
P.O. Number	:	Part Number	: D3325041
This Issue	: 6/6/2007 S.O. No. :	Drawing Number	: D3325 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: B
Previous Run	: 32535A	Material	:
Written By	:	Due Date	: 6/30/2007 Qty: 1 Um: Each
Checked & Approved By	: <u>[Signature]</u>		
Comment	: Est Rev: A 05.02.09 New issue KJJLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D33281	Basket Hinge
-----	--------	--------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3328-1 Hinge Plate B32846

PD 07-07-27 (1)

2.0	D33491	Spacer Bushing
-----	--------	----------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3349-1 Spacer Bushing B32588

PD 07-07-27 (1)

3.0	D33521	Label Plate
-----	--------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3352-1 Label Plate B28110

PD 07-07-27 (1)

4.0	D33671	Mounting Bracket
-----	--------	------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description

2 D3367-1 Mounting Bracket B32478

PD 07-07-27 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 32787A

Part Number: D3325041

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

M4130NTS0500W035

4130 Square tube .5 x .5



Comment: Qty.: 21.5687 f(s)/Unit Total: 21.5687 f(s)
Material: 4130 Cond. N Square tube per MIL-T-6736,
1/2" x 0.035" wall
M4130N-TS0.500W.035)

PD 07-07-27 (1)

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
1-Cut tubes as per Dwg D3325

Qty	Part Number	Description	Batch
2	D3325-1	EndTube	
3	D3325-3	Interior Tube	
2	D3325-5	Full Lengh Tube	

M104272

Identify parts appropriately

2-Remove all markings from material

3-Drill and Weld as per Dwg D3325 & QSI 004
A/RN/AS steel Rod H100075

4-Deburr as required

PD 07-07-27 (1)

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

11/07/07/30

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11/07/07/30

9.0

POWDER COATING

PRESSURE WASH BR 07-07-30



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FL 07/07/30 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 32787A

Part Number: D3325041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF

07-07-31

①

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

MF

07-07-31

①

12.0

QC21

FINAL INSPECTION/W/O RELEASE



07.08.02

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



07.08.01

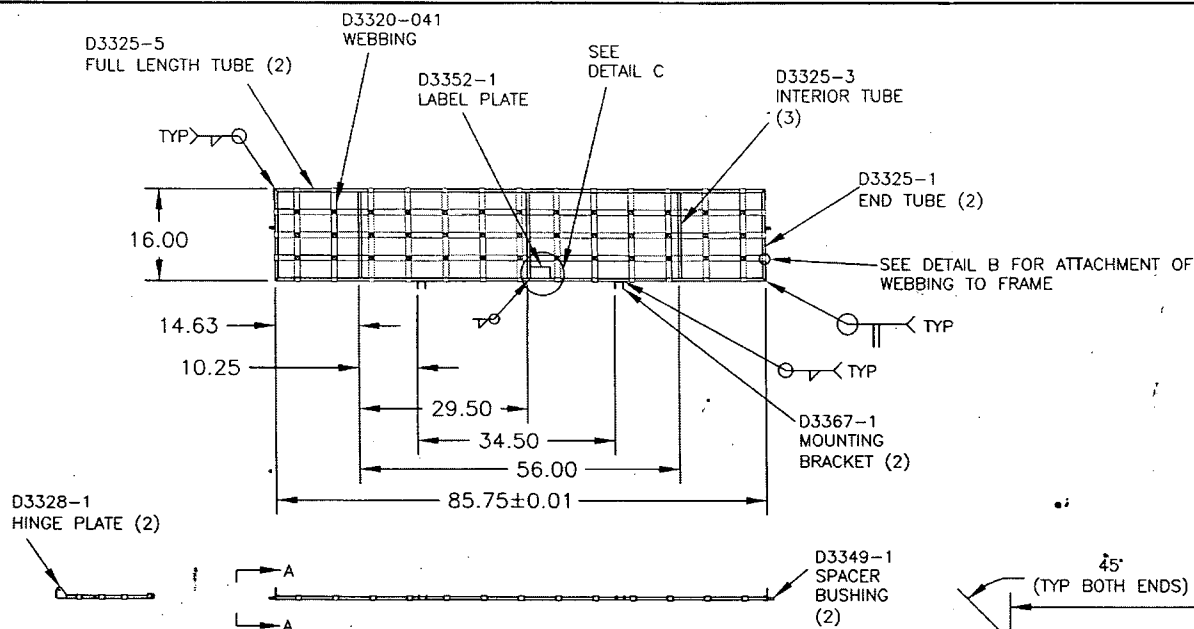
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

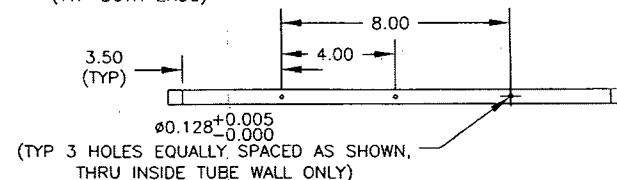
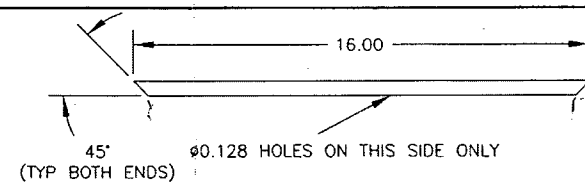


D3325-041 BASKET LID ASSEMBLY

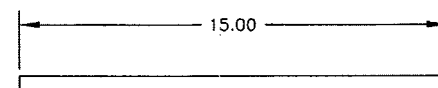
- 1) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3 (PRIOR TO INSTALLATION OF D3320-041)
- 2) WELD PER DART QSI 004
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

PARTS LIST FOR D3325-041 BASKET LID ASSEMBLY

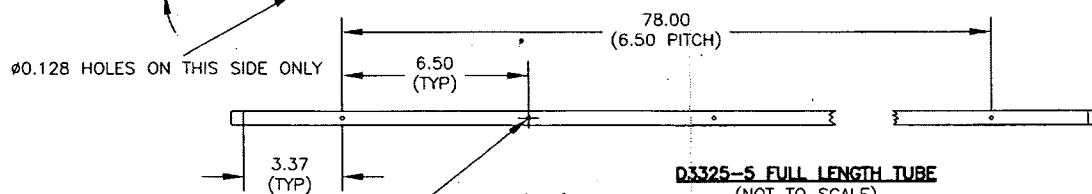
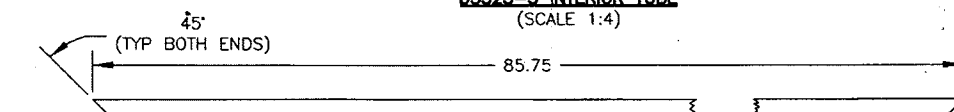
Part No.	Quantity	Description
D2729-1	1	PRODUCT ID LABEL
D3320-041	1	WEBBING
D3325-1	2	END TUBE
D3325-3	3	INTERIOR TUBE
D3325-5	2	FULL LENGTH TUBE
D3328-1	2	HINGE PLATE
D3349-1	2	SPACER BUSHING
D3351-1	1	PLACARD
D3352-1	1	LABEL PLATE
D3367-1	2	MOUNTING BRACKET
MS20600AD4V3	32	RIVET
AN960JD9	32	WASHER



D3325-1 END TUBE
(SCALE 1:4)



D3325-3 INTERIOR TUBE
(SCALE 1:4)



D3325-5 FULL LENGTH TUBE
(NOT TO SCALE)

D3325-1/-3/-5

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: 4130 COND. N SQ. TUBE, AMS-T-6736, 1/2" X 0.035 (REF. DART SPEC M4130N-TS0.500W.035)
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

B	05.04.25	CHANGE RIVET AND HOLE DIAMETER
A	04.10.21	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3325
DATE	05.04.25	TITLE BASKET LID ASSEMBLY

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D3325

BASKET LID ASSEMBLY

SHEET 1 OF 3

1:20

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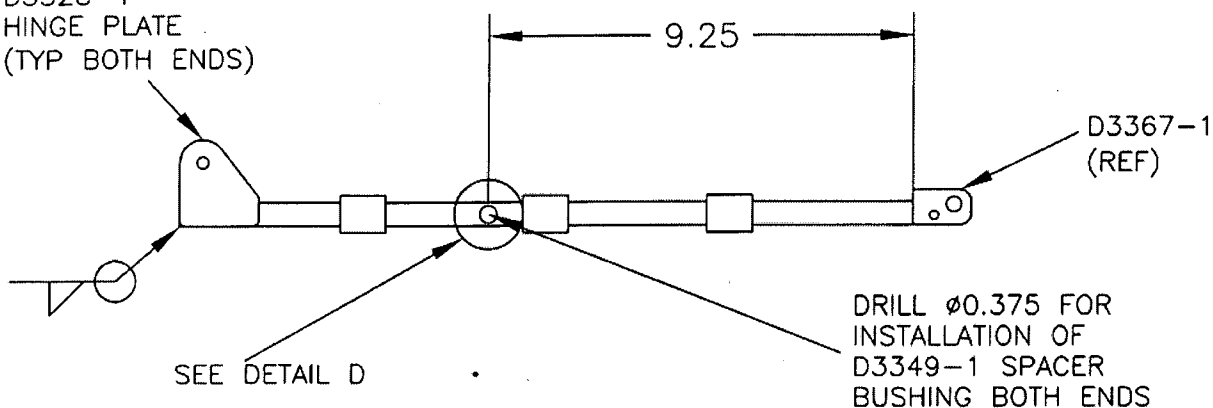
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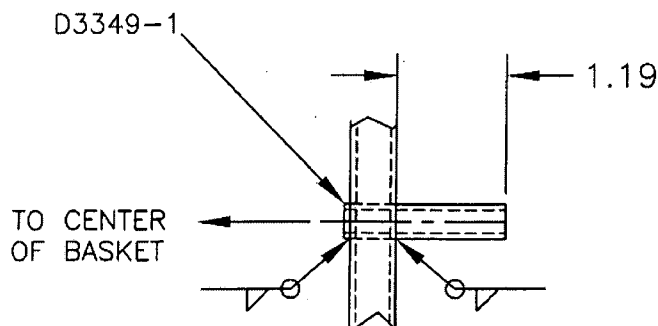


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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3325	REV. B SHEET 2 OF 3
DATE 05.04.25	TITLE BASKET LID ASSEMBLY		SCALE 1:4

D3328-1
HINGE PLATE
(TYP BOTH ENDS)



VIEW A-A



DETAIL D
(SCALE 1:2)

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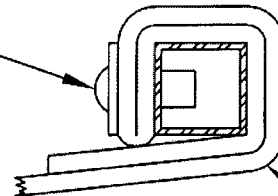
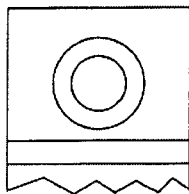
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CHECKED PH	APPROVED PH	DRAWING NO. D3325	REV. B SHEET 3 OF 3
DATE 05.04.25	TITLE BASKET LID ASSEMBLY		SCALE 1:4

MS20600AD4W3 RIVET (1)
AN960JD9 WASHER (1)

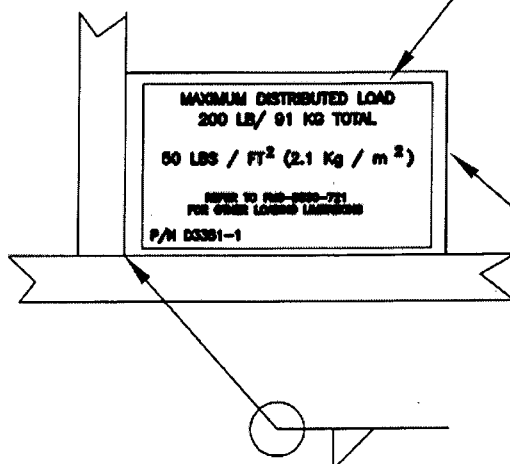


DETAIL B
TYP. ATTACHMENT OF WEBBING TO LID
FRAME
(SCALE 1:1)

D3320-041 WEBBING

RELEASED
05.04.28 PH

ATTACH D3351-1 PLACARD
ON TOPSIDE OF D3352-1



D3352-1

OUTBOARD

IDENTIFY WITH DART P/N
D350-721-041 USING
D2729-1 PRODUCT ID LABEL
INSTALLED ON UNDERSIDE OF
D3352-1

DETAIL C
LABEL PLATE ATTACHMENT
(SCALE 1:2)

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26

Date: Wednesday, 6/6/2007 1:53:20 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BASKET BASE ASSEMBLY
 Job Number : 32787B
 Estimate Number : 10852
 P.O. Number :
 This Issue : 6/6/2007 S.O. No. :
 Prsht Rev. : NC Part Number : D3324041
 First Issue : 1/1 Type : LARGE FAB ASSY Drawing Number : D33241 UNDER REVIEW ~~PH~~
 Previous Run : 32535B Project Number : N/A 07.06.07
 Drawing Revision : B
 Material :
 Due Date : 6/30/2007 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : 07.06.07
 Comment : Est Rev: A 05.02.09 New issue KJ/JLM

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D33283	Basket Hinge
-----	--------	--------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3328-3 Hinge Plate B32847

D 07-07-27 ①

2.0	D33481	Clevis
-----	--------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D3348-1 Clevis B32581 -> 1B32848 -> 3

D 07-07-27 ①

3.0	D33493	Spacer Bushing
-----	--------	----------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3349-3 Spacer Bushing B32589

D 07-07-27 ①

4.0	D33671	Mounting Bracket
-----	--------	------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3367-1 Mounting Bracket B32478

D 07-07-27 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 6/6/2007 1:53:20 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY

Job Number: 32787B

Part Number: D3324041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

M4130NTS0500W035

4130 Square tube .5 x .5



Comment: Qty.: 48.9300 f(s)/Unit Total : 48.9300 f(s)
Material: 4130 Cond. N Square tube per MIL-T-6736,
1/2" x 0.035" wall
M4130N-TS0.500W.035)

PD 07-07-27 ①

6.0

M569EX05018F

569 Expanded Metal



Comment: Qty.: 28.0000 sf(s)/Unit Total : 28.0000 sf(s)

Pick:

Qty Part Number Description

Batch

28s M569EX0.50-18F 1/2"-18gauge(.040") carbon steel

M104613

PD 07-07-27 ①

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut tubes as per Dwg D3324

Qty	Part Number	Description	Batch
3	D3324-1	Bottom Tube	
4	D3324-3	Full Length Tube	
2	D3324-5	Top End Tube	
2	D3324-7	Bottom End Tube	
10	D3324-9	Vertical Tube	

Identify parts appropriately

M104272

2-Remove all markings from material & check for foreign objects

3-Drill and Weld as per Dwg D3324 & QSI 004 using DT8781 A & B

A/RN/A Steel Rod M100075

4-Deburr as required

PD 07-07-27 ①

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/07/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 6/6/2007 1:53:20 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY

Job Number: 32787B

Part Number: D3324041

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/07/30

10.0

POWDER COATING

*PRESSURE POWDER COATING
BR 07-07-30
in 105068*



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FX 07/07/30 ①

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF 07-07-31 ①

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *G.A.*

MF 07-07-31 ②

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.08.02

Job Completion



MF 07.08.02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

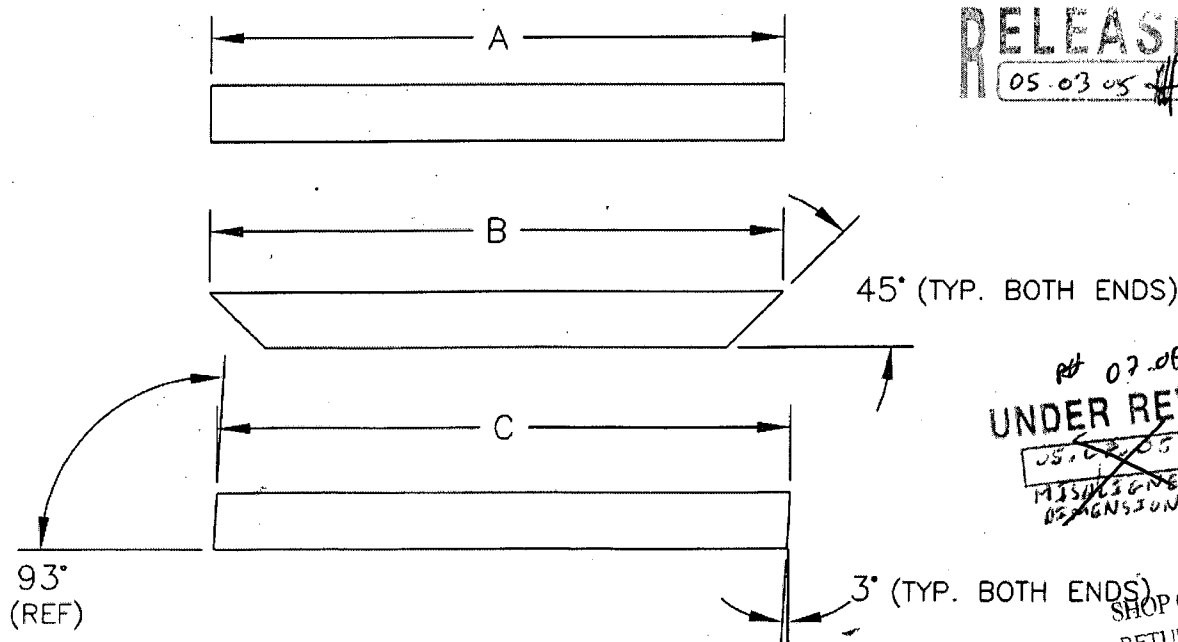
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CHECKED PH	APPROVED PH	DRAWING NO. D3324	REV. B SHEET 1 OF 3
DATE 05.03.04		TITLE BASKET BASE ASSEMBLY	SCALE NTS
A	04.10.20	NEW ISSUE	
B	05.03.04	UPDATE MESH MATERIAL SPEC	

PARTS LIST FOR D3324-041 BASKET BASE ASSEMBLY

Part No.	Quantity (-041)	Length A	Length B	Length C	Description
D3324-1	3	14.00	N/A	N/A	BOTTOM TUBE
D3324-3	4	N/A	86.50	N/A	FULL LENGTH TUBE
D3324-5	2	N/A	16.00	N/A	TOP END TUBE
D3324-7	2	N/A	15.00	N/A	BOTTOM END TUBE
D3324-9	10	N/A	N/A	11.04	VERTICAL TUBE
D3328-3	2	N/A	N/A	N/A	HINGE PLATE
D3348-1	4	N/A	N/A	N/A	CLEVIS
D3349-3	2	N/A	N/A	N/A	SPACER BUSHING
D3367-1	2	N/A	N/A	N/A	MOUNTING BRACKET



RELEASED
05.03.05

PH 07.06.07
UNDER REVIEW
05.02.05 PH
MISDESIGNED
DIMENSION P6 &

D3324-1/-3/-5/-7/-9

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: 4130 COND. N SQ. TUBE PER MIL-T-6736, 1/2" (REF. DART SPEC M4130N-TS0.500W.035)
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

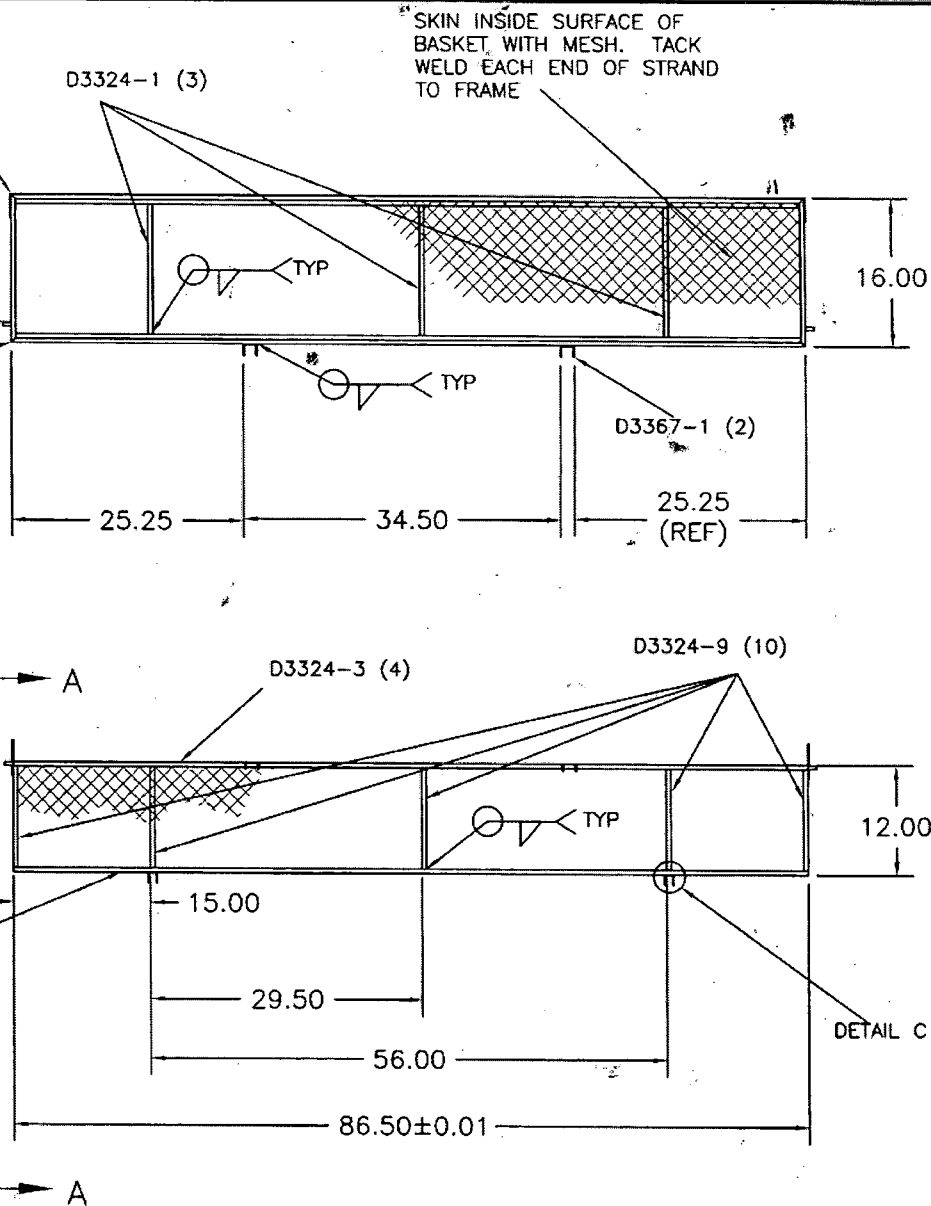
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DART

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE LTD	
CHECKED	PH	APPROVED	PH	HAMKESBURY, ONTARIO, CANADA	
DATE	05.03.04	TITLE	BASKET BASE ASSEMBLY	DRAWING NO.	D3324
				SHEET 2 OF 3	REV. B
				SCALE	1:20



RELEASED
05-03-05

SKIN INSIDE SURFACE OF BASKET WITH MESH. TACK WELD EACH END OF STRAND TO FRAME

UNDER REVIEW

D3324-041 BASKET BASE ASSEMBLY

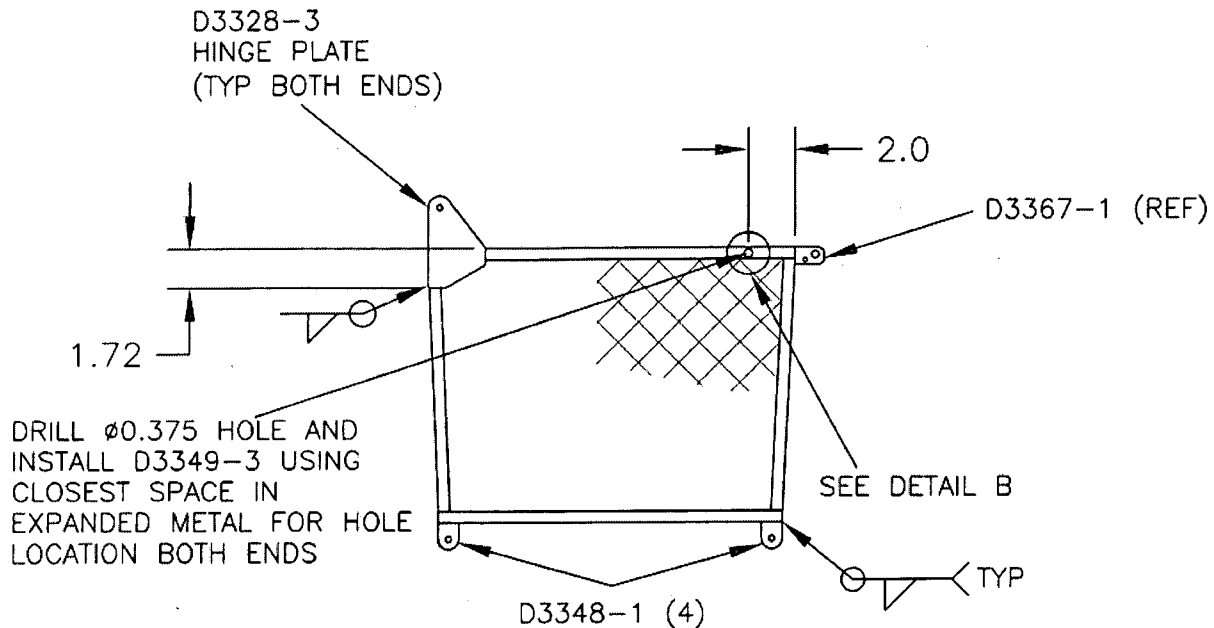
- 1) MESH MATERIAL: 1/2" - 18F GAUGE FLATTENED (0.040 THICK) EXPANDED CARBON STEEL (REF. DART SPEC. M569EX0.50-18F)
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 4.0 UNLESS OTHERWISE NOTED

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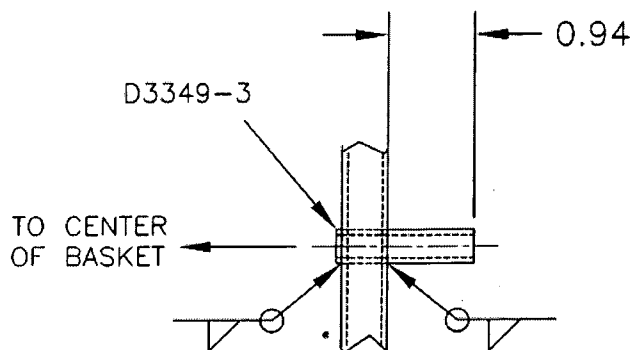


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DATE 05.03.04	TITLE BASKET BASE ASSEMBLY		SCALE 1:8

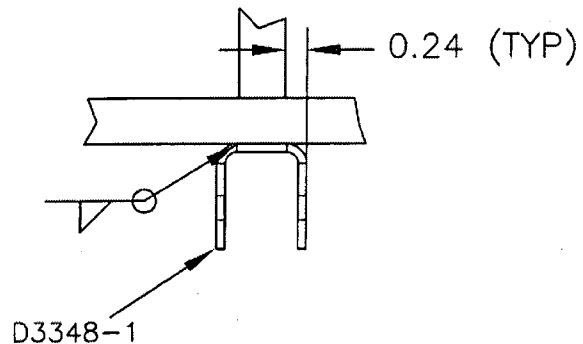


VIEW A-A

RELEASED
05.03.05



DETAIL B
(SCALE 1:2)



DETAIL C
(SCALE 1:2)

UNDER REVIEW

05.07.06

PH
07.06.07

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